

Date: Tuesday, 01/05/2007 2:25:50 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 31863
 Estimate Number : 12675
 P.O. Number : *NA*
 This Issue : 01/05/2007 S.O. No. : *NA*
 Prsht Rev. : NC
 First Issue : *NA* Type : MACHINED PARTS
 Previous Run : 31863
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est Rev:A New Issue 07-01-29 JLM

Drawing Name : ADAPTER

Part Number : D35735
 Drawing Number : D3573 REV.A
 Project Number : N/A
 Drawing Revision : A
 Material : *NA*
 Due Date : 13/05/2007

SPLIT

Qty: *31*
 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6B0500X02500 6061-T6 Bar .50" x 2.5"



Comment: Qty.: 0.3066 f(s)/Unit Total: 18.3960 f(s)

6061-T6 Bar .50" x 2.5"

Batch: ~~M104336~~ M104336

QML 07/05/17 *31*
~~SA 07.05.06~~

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank 3.250" long

QML 07/05/17 *31*
~~SA 07.05.06~~ *(31)*

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA674 and Dwg D3573

QML 07/05/17 *31*
~~SA 07.05.06~~ *(31)*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QML 07/05/17 *31*
~~SA 07.05.06~~ *29*

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MB *07/05/17* *31*
~~QML 07/05/17~~ *29*

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL *07/05/22* *(31)*

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADAPTER

Job Number: 31863

Part Number: D35735

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



M101601



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

HL 07-05-24 (31)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Pc 7/5/04

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

stagg Pc 7/5/04 (31)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



(31) P. 07/05/05

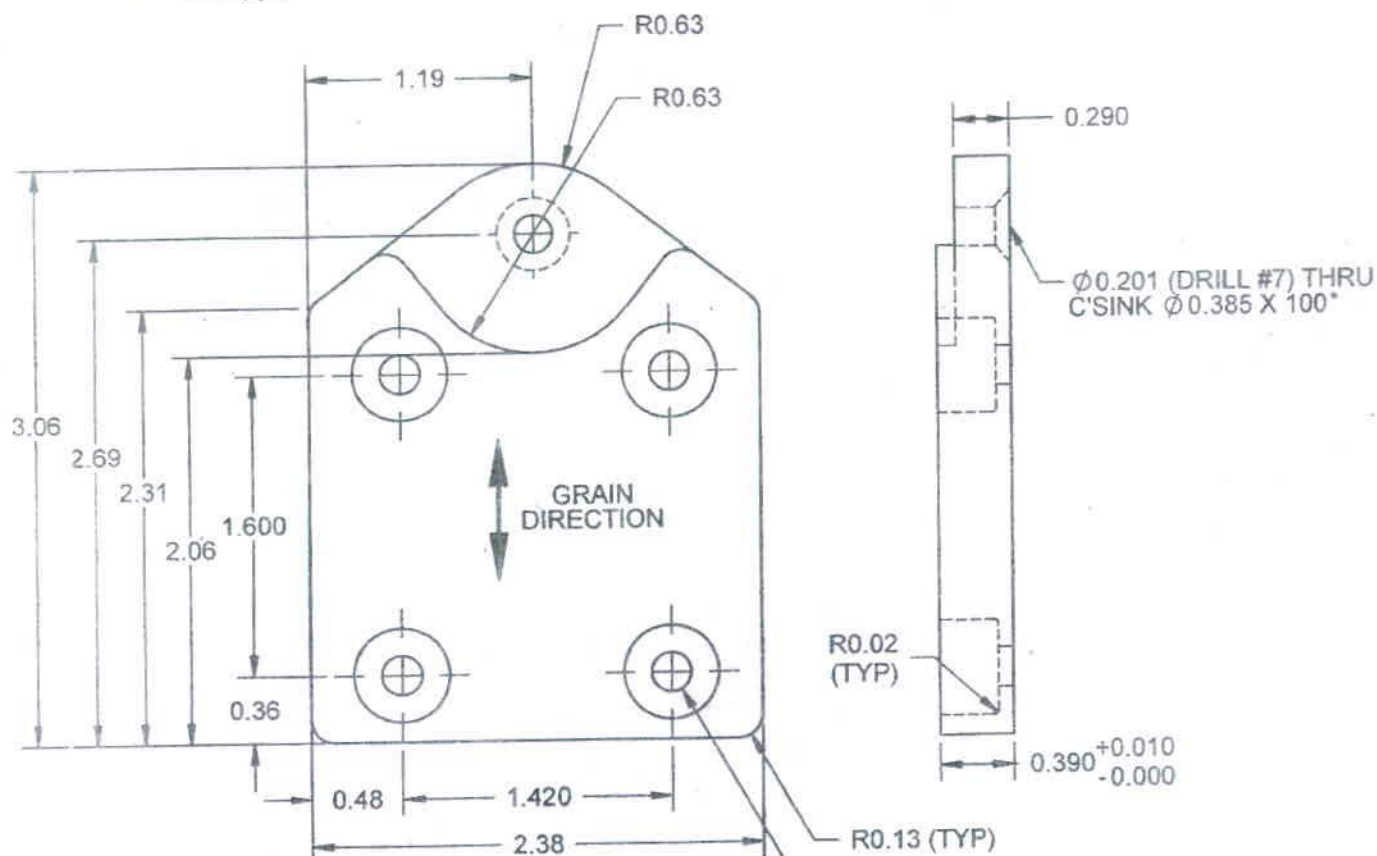
Job Completion



HL 07-05-25

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 3 OF 4
DATE 07.02.19	TITLE ADAPTER		SCALE 1:1

RELEASED
07.04.02**D3573-5 ADAPTER****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-5" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD		Work Order: 31863-2
Description: ADAPTER		Part Number: D3573-5
Inspection Dwg: D3573 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.06	± 0.30	3.060	—			
2.69	± 0.30	2.690	—			
2.06	± 0.30	2.062	—			
1.600	± 0.05	1.600	—			
0.36	± 0.36	0.355	—			
0.48	± 0.30	0.476	—			
1.420	± 0.05	1.420	—			
2.38	± 0.30	2.374	—			
R0.13	± 0.36	R0.125	—			
$\varnothing 0.209$	± 0.004 ± 0.001	$\varnothing 0.210$	—			
$\varnothing 0.500$	± 0.10	$\varnothing 0.500$	—			
0.310	± 0.10	0.310	—			
0.390	± 0.10 ± 0.000	0.395	—			
R0.02	± 0.36	R0.020	—			
0.290	± 0.10	0.291	—			
$\varnothing 0.201$	± 0.004 ± 0.001	$\varnothing 0.202$	—			
$\varnothing 0.385 \times 100^\circ$	± 0.10	$\varnothing 0.385 \times 100^\circ$	—			

Measured by: 	Audited by: 	Prototype Approval:
Date: 07/05/17	Date: 07-05-17	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



H.I.F.O.P.